

Work Order ID 63280

Wednesday, October 27, 2010 9:08:40 AM

Page 1

Item ID: D212-725-1-169F

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket Oil Cooler

Start Date: 10/27/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-10-27

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D212-725-1

E

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: E

Prog Rev: E

2-Deburr if necessary

10-10-28

3

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-10-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

10/10/28



QC

Memo

0.00

Quality Control

121

Hand finish

Acid & Alodine

122

QC 3

130

Identify as per dwg & Stock Location: 386

0.00



Packaging

Memo

0.00

Packaging

FLAT PATTERN ONLY

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

②

② BR 10-10-28.

10/10/29 ②

10/10/29

MF

10-10-29

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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 27, 2010 9:08:44 AM

Page 1

Work Order ID: 63280

Parent Item: D212-725-1-169F

Parent Item Name: Bracket Oil Cooler

Start Date: 10/27/2010

Required Date: 11/30/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	72.0000	0.05443	0.114589			



2024-T3 .032 sheet



1310-10-28

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT22	72	
105555	3	
111699	4	
113189	65	

113189

(3)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

D212-725-1169F

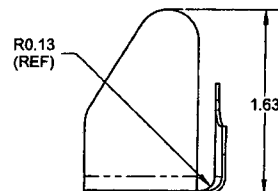
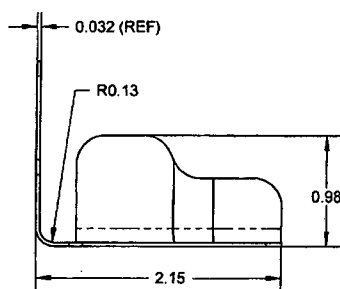
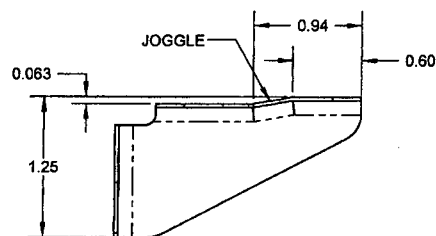
X	First Article	X	Prototype
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Measured by:	IB	Audited by:	S	Prototype Approval:	
Date:	10-10-29	Date:	10/10/28	Date:	

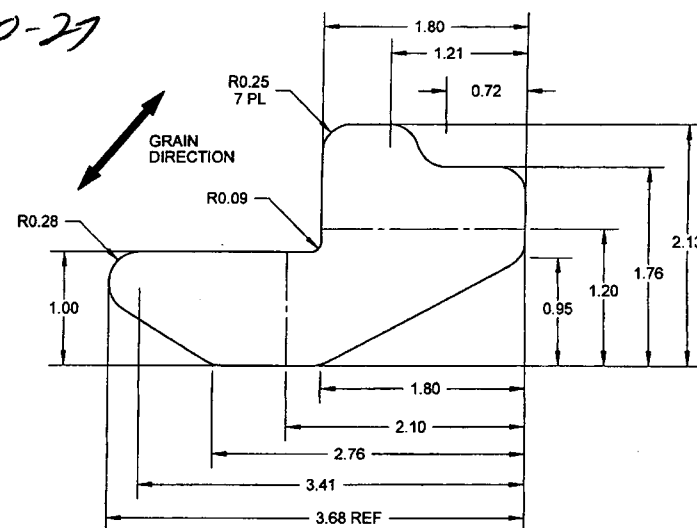
H:\FORMS\Quality Assurance\approved QA\FAI revD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63280

B810-10-27



D212-725-1-169 BRACKET
(MAKE FROM D212-725-1-169F)



D212-725-1-169F FLAT PATTERN

RELEASED
2009-10-28

- NOTES:
- 1) MATERIAL: 2024-T3 SHEET 0.032 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S.032)
 - 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME PER AIRCRAFT MAINTENANCE MANUAL
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: N/A

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DS	DRAWING NO.	REV. E
MFG. APPR.	N/A	D212-725-1	SHEET 58 OF 82
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	212S DETAIL PARTS	NTS
DATE	08.09.17	COPYRIGHT © 2006 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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